

Quality Control

Work Order ID 162333

Friday, June 02, 2017 10:37:59 AM

162333

Page 2

Item ID: D4775-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Strut Tube
Start Date: 6/5/2017 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 6/12/2017 Req'd Qty: 10.00 ***10*** Customer:
Reference: (P.A.)SCHEDULED/S

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.20				10			DAS 49 9-88 17/06/14
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.64				(X10)			20/06/15 BETB.
140 *140* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.10				10			17/06-15. DAS 34 9-88

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per OSI005 4.3-Alum <i>M137176</i> Memo START TIME: <i>7:55</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>8:25</i>	0.00 0.27				<i>10</i>	<i>0.17-06 16</i>	<i>233</i>	
155 *155* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.10				<i>10</i>			DAS 38 9-89 JUN 16 2017
160 *160* Packaging Packaging	Identify as per dwg & Stock Location: <i>5137</i> Memo	0.00 0.10				<i>10</i>	DAS 6 9-89	JUN 19 2017	

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	1.00							
Quality Control									

DAS
21
9-89

JUN 19 2017

Picklist Print

Friday, June 02, 2017 10:37:58 AM

Page 1

Work Order ID: 162333

162333

Parent Item: D4775-1

D4775-1

Parent Item Name: Strut Tube

Start Date: 6/5/2017

Required Date: 6/12/2017

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS IPP REV:B
13.09.26 AS PER REV.B DD VERF:JLM IPP REV:C 14.01.10
AS PER REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6T0.625W.125		Purchased	No			100	f	50.7150	1.15	12.10526			
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M6061T6T0 625W 125

**

SL 16-6-14

6061-T6 RD Tube 0.625 X.125W

Location

Loc Qty

Loc Code

MAT014

50.715

m135857

12.625

m137364

14.09

m137477

24

12

DQA: _____ Date: _____



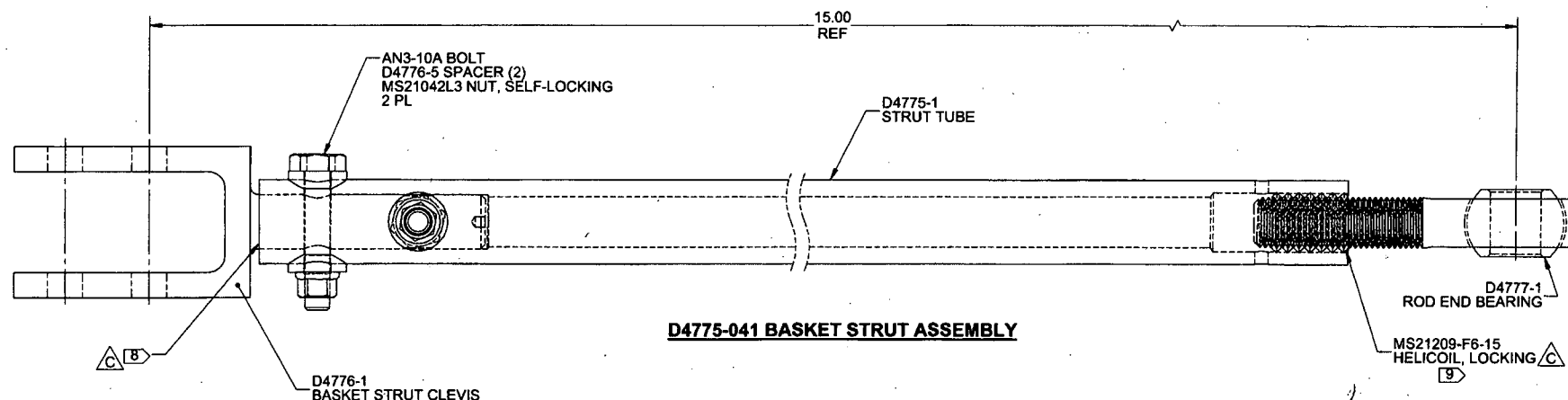
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

ITEM	QTY	P/N	DESCRIPTION
	X	D4775-041	BASKET STRUT ASSEMBLY
1	1	D4775-1	STRUT TUBE
2	1	D4776-1	BASKET STRUT CLEVIS
3	4	D4776-5	SPACER
4	1	D4777-1	ROD END BEARING
5	2	AN3-10A	BOLT
6	2	MS21042L3	NUT, SELF-LOCKING
7	1	MS21209-F6-15	HELICOIL, LOCKING



D4775-041 BASKET STRUT ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.45 lbs
- 8) APPLY PROSEAL 890 B-2 (PRC) TO THE STEM OF ITEM 2 TO PREVENT RATTLING.
- 9) ENSURE HELICOIL DOES NOT BLOCK HOLE.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 162333 RELEASED
2014-01-07
20170602

C	ITEM 7 WAS F6-20, B2-2 Ø0.098 "WITNESS HOLE" ADDED. REASON: CUSTOMER FEEDBACK. ADDED NOTE 8. REASON: DESIGN IMPROVEMENT.	AJS	13.11.01
B	DELETED WELD PINS (-3) REPLACED WITH FASTENERS. REASON: PREVENT CRACKING & EASE OF MANUFACTURE. C6-2 HOLE PATTERN ON -1 REVERSED TO ENSURE FASTENERS CLEAR STRUCTURE. FINISH NOTE MOVED TO -1 (SHEET 2).	AJS	13.08.14
A	NEW ISSUE	AJS	13.08.08
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO. REV. C	
MFG. APPR.		D4775 SHEET 1 OF 2	
APPROVED		TITLE SCALE	
DE APPR.		BASKET STRUT ASSEMBLY NTS	
DATE	13.11.01	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____

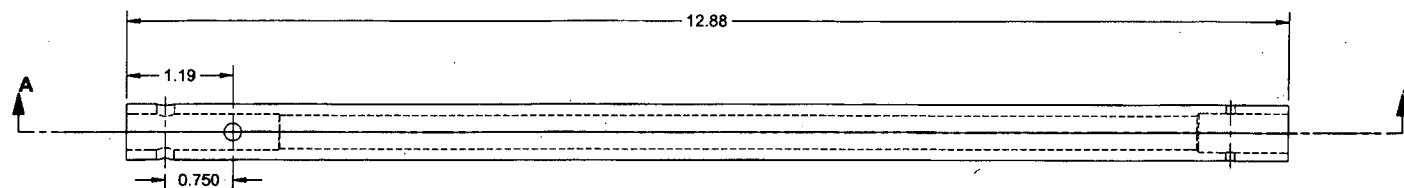
WORK ORDER NON-CONFORMANCE / UPDATE



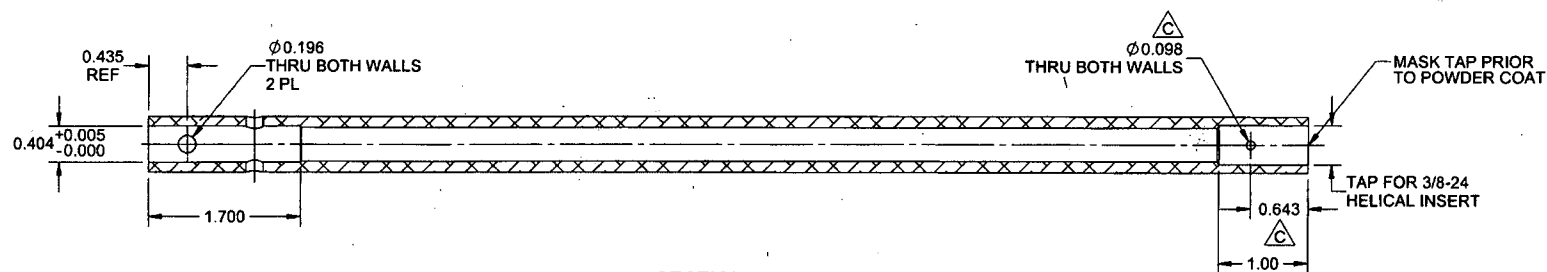
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Work Order update only ☐

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D4775-1 STRUT TUBE



SECTION A-A

RELEASED
2014-01-08

NOTES:

- 1) MATERIAL: 6061-T6/T62/T6510/T6511 SEAMLESS TUBING, $\phi 0.625 \times 0.125$ WALL
PER WW-T-700/8 OR QQ-A-200/8 OR QQ-A-225/8
OR AMS 4080 OR AMS 4082 OR AMS 4083
OR ASTM B210 OR ASTM B241
REF DART SPEC M6061T6T0.625W0.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.24 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.		D4775	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BASKET STRUT ASSEMBLY	NTS
DATE	13.11.01	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

DQA: _____ Date: _____



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OTHER : _____					